



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

SOLD - May 1

D5101-047
Job Sheet 175235



Part No: D5101-047

Job Qty: 5 ea

Part Name: Crossbolt Spacer Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/29/18

Job Tracking No:

Due Date: 4/16/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV C SHEETS 5,6 IPP Rev.A New issue JFS 15/09/29 Verified by: DD IPP REV:B 15.12.10 AS PER DWG REVB DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	4/14/18	4/14/18	0.00	0.00	Start Up Machining-3		<i>18-05-17</i>
100	Bandsaw	5 pcs	4/14/18	4/14/18	0.00	0.00	Bandsaw1		
110	CNC Vertical Machining	5 pcs	4/14/18	4/14/18	0.00	4.00	HAAS 5 Axis		
120	QC	5 pcs	4/14/18	4/14/18	0.00	0.00	QC2 Machining-3		
130	QC	5 pcs	4/14/18	4/14/18	0.00	0.00	QC8 Machining-3		
140	Small Fab	5 pcs	4/16/18	4/16/18	0.00	0.50	Small Fab-8		<i>18-05-28</i>
170	QC	5 pcs	4/16/18	4/16/18	0.00	0.00	QC5		
180	Packaging	5 pcs	4/16/18	4/16/18	0.00	0.00	Packaging3-2	FP-001	
190	QC21-SA	5 Ea	4/16/18	4/16/18	0.00	0.00	QC21		

Part Op 100 - Cut blank 2.200" long
 Descriptions: 110 - 1- Mill as per Folio FB426 DWG Rev: _____ FOLIO REV: _____ 2-Deburr per dwg
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 170 - QC5- Inspect part completeness to step on W/O
 180 - Identify as per dwg & Stock Location: _____
 190 - QC21- Final Inspection - Work Order Release

21 MAY 29 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINB1.000X4.000	Delrin Bar	.9200 ft (.184 ea)	90-Start up Operation	<i>S072224</i>
MS21209F7-10	Heli-Coil, Locking	20 Ea (4 ea)	140-Small Fab	<i>FM137321-40</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINB1.000X4.000	1	22	0
140-Small Fab	MS21209F7-10	20	56	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

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Container No: S072225



Part: D5101-047

Job No: 175235

Serial No/Batch: S072225

Revision:

Inspector:

Date: 06/17/18

DART AEROSPACE LTD		Work Order: 175 235
Description: Crossbolt Spacer Assembly		Part Number: DS101-7
Inspection Dwg: DS101 Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R 5.00	+/- .030	5.000	✓		5/10 Vern	
15°	+/- .5°	15°	✓			
.18	+/- .030	.171	✓			
R 1.85	+/- .030	1.850	✓			
Ø .230	+ .005/- .001					
1/4-20 UNC 2A		1/4-20	✓			Thread gauge
R .25	+/- .030	.250	✓			
.066	+/- .010	.057	✓			
19.67°	+/- .03°	19.67°	✓			
1.56	+/- .030	1.562	✓			
3.676	+ .000/- .005	3.673	✓			
.81	+/- .030	.810	✓			
1.48	+/- .030	1.483	✓			
.63	+/- .030	.625	✓			
Ø .453	+ .006/- .001	.453	✓			
7/16-20 STI		7/16-20	✓		Thread gauge	
.75 deep	+/- .030	.750				
	DAS					

Measured by: 20 9-89	Checked by: gml	QC Inspector:
Date: 18-05-16	Date: 18/05/22	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	